JET
EQUIPMENT & TOOLS

OWNER'S MANUAL
XACTA FENCE II™ Commercial 30/50

JET EQUIPMENT & TOOLS, INC.
A WMH Company
www.jettools.com

P.O. BOX 1349
Auburn, WA 98071-1349
e-mail jet@jettools.com

253-351-6000
Fax 253-939-8001
M-708950X 3/01

Important Information

2-YEAR **LIMITED WARRANTY**	**JET offers a two-year limited warranty on this product**

REPLACEMENT PARTS

Replacement parts for this tool are available directly form JET Equipment & Tools.
To place an order, call 1-800-274-6848. Please have the following information ready:

1. Visa, MasterCard, or Discover Card number
2. Expiration date
3. Part number listed within this manual
4. Shipping address other than a Post Office box.

REPLACEMENT PART WARRANTY

JET Equipment & Tools makes every effort to assure that parts meet high quality and durability standards and warrants to the original retail consumer/purchaser of our parts that each such part(s) to be free from defects in materials and workmanship for a period of thirty (30) days from the date of purchase.

PROOF OF PURCHASE

Please retain your dated sales receipt as proof of purchase to validate the warranty period.

LIMITED TOOL AND EQUIPMENT WARRANTY

JET makes every effort to assure that its products meet high quality and durability standards and warrants to the original retail consumer/purchaser of our products that each product be free from defects in materials and workmanship as follows: 2 YEAR LIMITED WARRANTY ON THIS JET PRODUCT. Warranty does not apply to defects due directly or indirectly to misuse, abuse, negligence or accidents, repairs or alterations outside our facilities or to a lack of maintenance. JET LIMITS ALL IMPLIED WARRANTIES TO THE PERIOD SPECIFIED ABOVE FROM THE DATE THE PRODUCT WAS PURCHASED AT RETAIL. EXCEPT AS STATED HEREIN, ANY IMPLIED WARRANTIES OR MECHANTABILITY AND FITNESS ARE EXCLUDED. SOME STATES DO NOT ALLOW LIMITATIONS ON HOW LONG THE IMPLIED WARRANTY LASTS, SO THE ABOVE LIMITATION MAY NOT APPLY TO YOU. JET SHALL IN NO EVENT BE LIABLE FOR DEATH, INJURIES TO PERSONS OR PROPERY OR FOR INCIDENTAL, CONTINGENT, SPECIAL OR CONSEQUENTIAL DAMAGES ARISING FROM THE USE OF OUR PRODUCTS. SOME STATES DO NOT ALLOW THE EXCLUSION OR LIMITATION OF INCIDENTAL OR CONSEQUENTIAL DAMAGES, SO THE ABOVE LIMITATION OR EXCLUSION MAY NOT APPLY TO YOU. To take advantage of this warranty, the product or part must be returned for examination, postage prepaid, to an authorized service station designated by our Auburn office. Proof of purchase date and an explanation of the complaint must accompany the merchandise. If our inspection discloses a defect, JET will either repair or replace the product or refund the purchase price, if we cannot readily and quickly provide a repair or replacement, if you are willing to accept such refund. JET will return repaired product or replacement at JET's expense, but if it is determined there is no defect, or that the defect resulted from causes not within the scope of JET's warranty, then the user must bear the cost of storing and returning the product. This warranty gives you specific legal rights, and you have other rights, which vary, from state to state.

XACTA FENCE II™ COMMERCIAL 30/50

Note: This manual also runs through the steps of installing the rails, and extension table.

⚠ WARNING

Disconnect the table saw from the power source before attempting any assembly or adjustment! Failure to comply may cause serious injury!

Contents of the Shipping Containers

1 XACTA FENCE II™
1 Front Rail
1 Rear Rail
1 Guide Rail
3 Black Plastic End Caps
1 Hardware Package
1 Owner's Manual
1 Warranty Registration Card

Tools Required for Assembly & Adjustment

1 #3 Cross Point Screwdriver
1 7/16" Wrench
1 1/2" Wrench
1 Combination Square & Straight Edge
1 Electric Drill
1 1/4", 3/16" Drill Bits
2 4"-6" C-Clamps
1 1/4", 3/16" Allen Wrenches

Front and Rear Rail Assembly

Note: The hardware should be packed in the guide rail along with the end caps.

Assembly Note: Depending on the size of the extension table you are using, you may need to remove the right side extension wing. You need to have four bolts attaching the extension table to the front and rear rails. Use a JET extension table or one designed and built by the operator. If you are planning to build a table, see Figure 1 for the dimensions.

1. Bolt the front rail to the table (not to the extension wing at this time) with two 1/4"-20 x 1-1/4" hex cap screws, four 1/4" flat washers, two 1/4" lock washers and two 1/4" hex nuts. Tighten just enough to hold the rail next to the table but keep loose enough to allow height adjustment.

2. Setting the combination square at 9/16" will clear the miter gauge slot.

3. Place the combination square on the table and adjust the rail to approximately 9/16" below the table surface, see Figure 2. **Note:** It is **more important** to have the front rail parallel to the table top than exactly 9/16" below the table top.

4. Tighten hex cap screws.

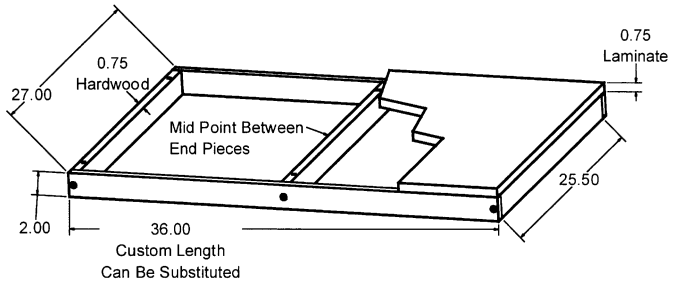

Fig. 1

Fig. 2

Assembly Note: To insure that you have enough adjustment in the cursor during the final adjustments, at this time you should bolt the guide rail to the front rail with two hex cap screws. Place the fence on the guide rail so that the cursor lines up at four inches. Measure from the saw blade to the fence and adjust the front rail so that you are as close to four inches as possible. You do not have to adjust the cursor at this time. Remove the fence and guide rail and continue with assembly instructions.

5. Bolt the front rail to the right extension wing with one 1/4”-20 x 1-1/4” hex cap screw, two 1/4” flat washer, one 1/4” lock washer, and one 1/4” hex nut.

6. Place the switch bracket assembly behind the hole in the left extension wing.

7. Insert a 1/4”-20 x 1-1/4” hex cap screw and 1/4" flat washer through the guide rail, extension wing, and the switch bracket. Hold in place with a 1/4" flat washer, 1/4" lock washer and 1/4" hex nut.

8. Push the switch bracket up as high as possible and tighten the hex nut firmly.

9. Bolt the rear rail to the table (not to the extension wings at this time) with two 5/16” x 1/2” hex cap screws, and two 5/16” flat washers. These are larger in diameter than the other screws in the hardware package.

Note: It is not critical for the rear rail to be absolutely level. It is, however, important for the rear rail to clear the miter slots and be level as possible.

10. Bolt the rear rail to each extension wing with two 1/4”-20 x 1-1/4” hex cap screws, four 1/4” flat washers, two 1/4” lock washers, and two 1/4” hex nuts.

11. Tighten nuts.

Note: Mount the extension table between the front and rear rails before mounting the front guide rail.

Extension Table Assembly

1. Place the extension table upside down on top of the table saw.

2. Place a leg bracket into the outboard end of the table.

3. Mark all holes to be drilled.

4. Pre-drill all marked holes with a 3/16” drill bit approximately 1/2” deep. **Do not drill through the table top or table frame!**

5. Attach both legs with supplied wood screws, see Figure 3.

6. Carefully turn the table over and place in between the front and rear rail.

7. Use two c-clamps to hold the table in place.

8. Place a straight edge on the saw table and level the extension table to the saw table. Raise or lower the adjustable feet on the extension table legs until the extension table is level with the saw table. Tighten the c-clamps to hold in place.

9. Using the existing holes in the front and rear rail as a guide (two front and two rear), drill through the table frame using a 1/4” drill bit.

10. Attach extension table to the front and rear rail with four 1/4”-20 x 1-1/4” hex cap screws, eight 1/4” flat washers, four 1/4” lock washers, and four 1/4” hex nuts. This hardware is supplied with the extension table.

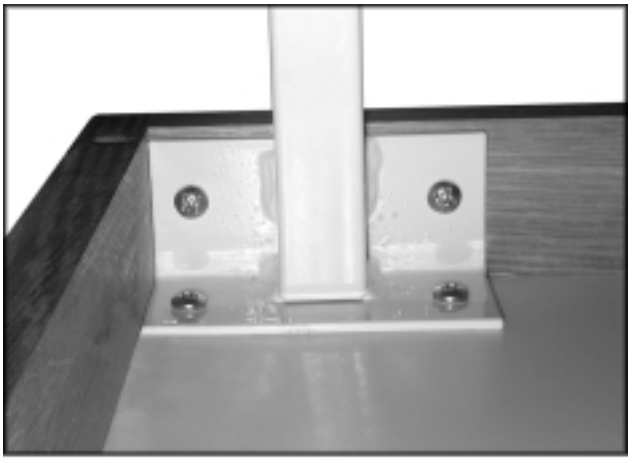

Fig. 3

Guide Rail Assembly

1. Bolt the guide rail to the front rail with 1/4-20 x 3/4” hex cap screws 1/4" flat washers and 1/4" lock washers. Center the bolt heads in the slotted holes of the rail so you will have some lateral adjustment.

2. Measure from the front of the guide rail to the front of the tablesaw table in a couple spots to verify that the guide rail is parallel to the table. Adjust as needed and tighten.

Fence Assembly and Adjustments

1. Thread the handle knob into the cam assembly.

Note: Fence adjustments should be performed in the order given.

Level with the Saw Table

1. Place the fence on the table and lock it.

2. View the fence from the left side of the saw. Look for the space between the table and the fence bottom to be equal along the entire length of the fence.

3. If adjustment is necessary, unlock the fence.

4. Raise or lower two nylon adjustment screws (A, Fig. 4) **the same number of turns** until the space between the bottom of the fence and the table is the same. Care must be taken to raise or lower the fence on each side equally or the fence may not be 90° to the table after the height adjustment is performed.

Parallel to the Miter Slot

1. Place the fence next to the outside edge of the right miter slot and lock it.

2. The fence should be even with the miter slot from front to back.

3. If the fence is not even along the length of the miter slot, unlock the fence, remove it and turn upside down.

4. Adjust one of the two set screws (A, Fig. 5) until the fence is even with the miter slot edge along its entire length when locked.

Note: You may need to re-adjust the clamping pressure after aligning the fence.

Clamping Pressure

The XACTA FENCE II™ has been adjusted at the factory to lock securely when the lock handle is pushed down. If adjustment is needed:

1. Unlock the fence.

2. Remove the fence from the guide rail.

3. Turn the fence over.

4. Adjust the two set screws (A, Fig. 5) until the fence is held securely when the lock handle is pushed down.

Fig. 4

Fig. 5

90° to the Table

1. Place the fence on the saw table and lock it.

2. Place a square on the table next to the fence. The fence should be 90° to the table, Figure 6.

3. If adjustment is necessary, unlock the fence, and turn one of the two nylon adjustment screws (A, Fig. 7) until the fence is 90° to the table.

4. Lock the fence and check the adjustment again.

Fig. 6

Cursor Adjustment

1. **Disconnect the table saw from the power source.**

2. Raise the saw blade above the tabletop.

3. Unlock the fence and slide it to approximately four inches from the saw blade.

4. Lock the fence.

5. Measure the distance between the saw blade and the inside of the fence.

6. Adjust the cursor to read the distance just measured and tighten the cursor assembly to the fence.

7. Take a test cut and confirm the adjustment is correct.

Fig. 7

Note: If the cursor does not have enough travel to give the correct measurement loosen the guide rail and adjust as needed. If you still do not get the correct measurement loosen the front rail and adjust as needed. If you have to adjust the front rail you will need to go through the front rail assembly instructions again.

This adjustment must be checked whenever a different blade is installed.

After installing the XACTA FENCE II™ press the black plastic end caps into the openings of the guide rail. There is also an end cap for the fence, but this should already be installed.

Parts List for the JET XACTA FENCE II™Commercial 30/50

Index No.	Part No.	Description	Size	Qty.
1	XF-1	Side Plate		2
2	XF2-2W	Fence Body Assembly		1
3	XF2-3	Pad Set		1
4	XF-4	Brass Plated Pan Head Machine Screw	10-32 x 3/4	12
5	XF-5	Nylon Adjustment Screw		2
8	TS-0271031	Set Screw	3/8 x 3/8	2
9	800708950D	Cursor		1
9A	800708950C	Cursor Bracket		1
10	TS-081D022	Pan Head Phillips Machine Screw	10-32 x 3/8	2
11	TS-069204	Flat Washer	No. 10	4
12	TS-056008	Hex Machine Screw Nut	10-32	2
	TS-081D021	Flat Phillips Machine Screw	10-32 x 3/8	2
13	TS-0640071	Nyloc Nut	1/4-20	1
14	TS-0050081	Hex Cap Bolt	1/4 x 1-3/4	1
15	TS-0060081	Hex Cap Bolt	3/8 x 1-3/4	1
16	TS-0640091	Nyoc Nut	3/8-16	1
18	3215301	Foot		1
19	3076232	Locking Cam		1
20	6430055	Knob w/Stud		1
21	6813092	Spring		1
	XF-EC	Black Plastic End Cap (not shown)		3
	XF2-21W	Front Rail (not shown)	50”	1
	XF2-21-30W	Front Rail (not shown)	30”	1
	XF2-22W	Rear Rail (not shown)	50”	1
	XF2-22-30W	Rear Rail (not shown)	30”	1
	XF-23W	Guide Rail (not shown)	50”	1
	XF-23-30W	Guide Rail (not shown)	30”	1
	XF-24	Measuring Tape (not shown)		1
	XF-HK-N	Hardware Kit (not shown)		1

XF-HK-N Hardware Kit contents:

6 ..... 1/4-20 x 1-1/4” hex cap screws
12 ... 1/4” lock washers
22 ... 1/4” flat washers
6 ..... 1/4-20 hex nuts
1 5/16-18 x 1/2 hex cap screws
2 ..... 5/16” Flat Washers
6 ..... 1/4-20 x 3/4” hex cap screws

The specifications in this manual are given as general information and are not binding. JET Equipment and Tools reserves the right to effect, at any time and without prior notice, changes or alterations to parts, fittings, and accessory equipment deemed necessary for any reason whatsoever.

Parts Breakdown